

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013232**Date Inspected:** 04-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Du Zhi Qun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10:

This QA Inspector performed Randomly Visual Inspection and Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as Tower Strut. The weld designations reviewed are as follows.

ND1-STSA3-1-89M-1-9,10,32,35,18,45,49,15,46,44,23,21,33,11,12,34,38

NDT Notification No-005266

This QA Inspector observed the following work in progress:

BAY 10

Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 050289 Perform Shielded Metal Arc Welding (SMAW) on Skirt Plate, I ribs Buttering up to 3~9mm on Skirt Plate, NSD1-A803A/B I rib, ZPMC QC Identified as Yuan Hai Gang. With Temporary welding repair report, WRR-T-WR3075, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with

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WPS-345-SMAW-2G(2F)Repair. For more information see below attached photo.

Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 500363, 040582 Perform Shielded Metal Arc Welding (SMAW) on Skirt Plate, Buttering up to 3~9mm on Skirt Plate and I ribs, SSD1-A803A/B, I ribs, ZPMC QC Identified as Yuan Hai Gang. With Temporary welding repair report, WRR-T-WR3082, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G, 3G(2F, 3F)Repair. For more information see below attached photo.

This QA Inspector observed during random Visual inspection, ZPMC Magnetic Particle Testing (MT) Inspector performed MT on Tower Strut. Item identified as ED1-A6001-7. For more information see below attached photo.

This QA Inspector observed ZPMC qualified welding personnel identified as 040460. Perform Submerged Arc Welding (SAW) on Tower Grillage beam plate. Joint identified NSD1-TL5-3B-F-19B, ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3221-B-U3c-S-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040460. Perform Submerged Arc Welding (SAW) on Tower Grillage beam plate. Joint identified NSD1-TL5-3B-F-19B, ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3221-B-U3c-S-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040489. Perform Submerged Arc Welding (SAW) on Tower Grillage beam plate. Joint identified SSD1-TL5-1B-F-21A, ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3221-B-U3c-S-1.

BAY 11

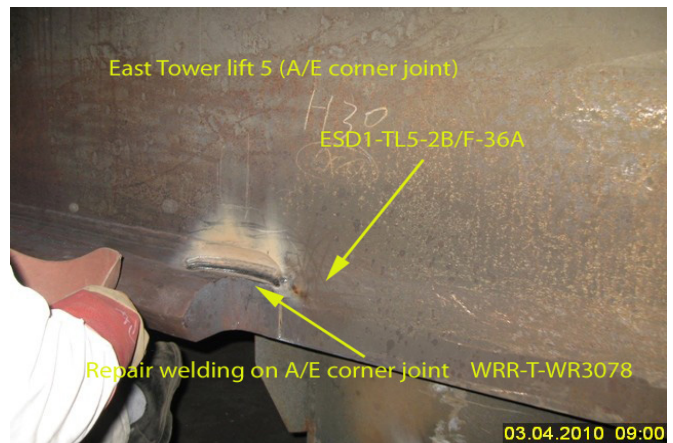
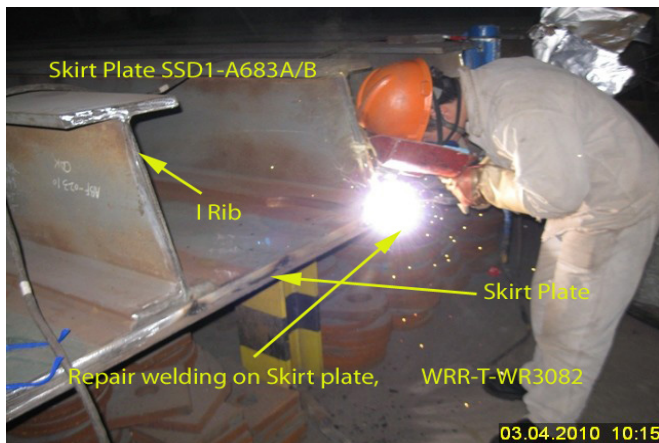
Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 046704. Perform Shielded Metal Arc Welding (SMAW) on East Tower lift 5 A/E corner joint. Joint identified, as ESD1-TL5-2B/F-36A, ZPMC QC Identified as Shao Hai Loang. With Temporary welding repair report, WRR-T-WR3078, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-2G (2F)-Repair-1. For more information see below attached photo.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest phone: 15000422360, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer